

Dorev 64382

Work Order ID 54124



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November 30, 2009 12:51:11 PM

Item ID: D3602-1

Accept



Setup Start



Revision ID: B

Item Name: Angle

Stop



Start Date: 01/12/2009 Start Qty: 9.00



Cust Item ID:

Required Date: 07/12/2009 Req'd Qty: 9.00



Customer:

Reference:

Approvals:

Process Plan:

PL

Date:

01-11-30

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3602

Rev B

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3602
Deburr if necessary

☐ Dwg Rev: *B*

☐ Prog Rev: *B*

☐ 2-

B 9-12-0

(11)

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

B 9-12-0

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

=> 8 02/12/02

(Full)

6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3602-1 PAR #: _____ Fault Category: Small Flab NCR: Yes No DQA: [Signature] Date: 16-12-02
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: [Signature] Date: 10/12/02

NCR: <u>54124</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
9/12/02	#130	• During Forming it was found that a "crack" was air through out the Bend Radius on the out side.	<u>[Signature]</u>	- no grain direction on Draw - Right Radius on part. - none of the other parts have this occurring	<u>n/g</u>	<u>[Signature]</u> 9/12/02	<u>[Signature]</u>	<u>[Signature]</u> 10/12/02
		Part looks like the mat. grain is opening up during Bending R.C. process.	<u>[Signature]</u>	- Scrap and Destroy no Replace - use for a template ✓ - ident: fix as reference only.	<u>[Signature]</u> 9/12/02	<u>[Signature]</u> 10/12/02	<u>[Signature]</u>	<u>[Signature]</u> 10/12/02

NOTE: Date & initial all entries

Work Order ID 54124

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Item ID: D3602-1

Accept



Setup Start



Revision ID: B

Stop



Item Name: Angle

Start Date: 01/12/2009 Start Qty: 9.00



Cust Item ID:

Required Date: 07/12/2009 Req'd Qty: 9.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/12/02

MRF

10-11-29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 1

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Work Order ID: 54124

Parent Item: D3602-1RevB

Parent Item Name: Angle


Comments:

Start Date: 01/12/2009

Required Date: 07/12/2009

Start Qty: 9.00

Required Qty: 9.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304S20GA 		Purchased	No			100	sf	323.4471	5.5421	6.7736		
304/316 .040 Sheet												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	323.4471158	
110076	1.37053684	
112567	38.0765789	
112885	83.1578	
113062	175.8422	
113077	25	

HB 9-12-2

(11)

113077

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

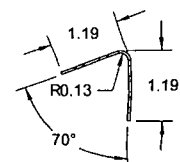
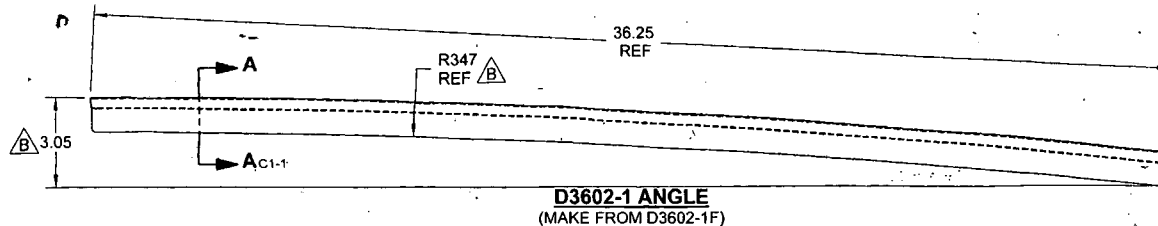
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

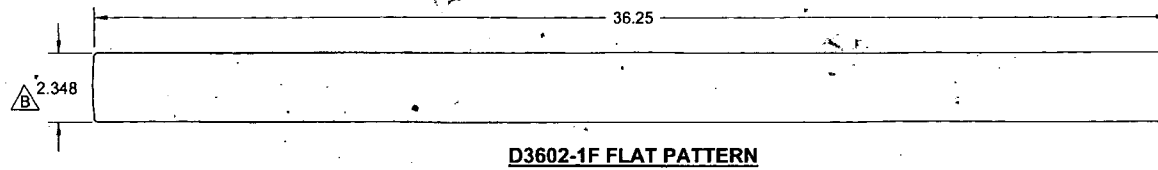
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1



SECTION A-A C7-1
SCALE 2X



RELEASED
07/03/11 JMB

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 20 GAUGE, 0.038 THICK, PER AMS 5513 OR AMS 5524, REF. DART SPEC. M304S20GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFY WITH DART P/N "D3602-1" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.97 lbs

54124
BY 09-11-30

B	ADDED ROUNDED SHAPE: R347 REF AND 3.05; 2.348 WAS 2.328. REF: NCR#09-014	MB	09.02.02
A	NEW ISSUE	MB	07.02.20
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.02.02		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D3602
TITLE: ANGLE
REV. B
SHEET 1 OF 1
SCALE: NTS

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8 7 6 5 4 3 2 1